



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200



D350-748-143TRN
Job Sheet 173668



Part No: D350-748-143TRN

Job Qty: 1 ea

Part Name: Ss Crosstube Turning Detail



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/6/18

Job Tracking No:

Due Date: 4/18/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV A NEW ISSUE - PRELIM - LL 12.05.08

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		4/17/18	0.00	0.00	Start Up Crosstubes-1		M.D. 18-06-20
100	Mori Seiki	1 pcs		4/17/18	7.06	2.81	Mori Seiki TL-40		M.D. 18-06-27
110	QC	1 pcs		4/17/18	0.00	0.00	QC2-1		M.D. 18-06-27
120	Mori Seiki	1 pcs		4/17/18	0.00	2.81	Mori Seiki TL-40		M.D. 18-06-27
130	QC	1 pcs		4/17/18	0.00	0.00	QC2-1		M.D. 18-06-27
140	QC	1 pcs		4/17/18	0.00	0.00	QC8		GP 18-06-20
150	Crosstubes	1 pcs		4/18/18	0.00	0.97	Crosstubes-2		GP 18-06-27
190	Packaging	1 pcs		4/18/18	0.00	0.00	Packaging3-1		GP 18-06-27
200	QC21-SA	1 Ea		4/18/18	0.00	0.00	QC21		GP JUN 27 2018

Part Op 100 - 1-Cut tube on chop saw, leave extra mat'l for facing and install plugs 350-141 on both ends. 2-Face both sides of Descriptions: tube. 3- Turn program 02000 section on both side as per folio FB467. 4- Turn program 03000 section on both side as per folio FB467. 5- Blend transsition lines only with belt sander 60 grit Dwg rev: A
120 - 1- Turn program 04000 section on both side as per folio FB467. 2- Blend transsition lines only with belt sander 60 grit 3- Scribe part # as per Dwg D350-748-143
130 - PERFORME ULTRASONIC MEASUREMENT
150 - 1-Grind machining marks
190 - Identify and stock in kanban rack

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6021-125	Crosstube Material - 17-4Ph SS	1 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6021-125	1	71	0

B127272

Part Specifications

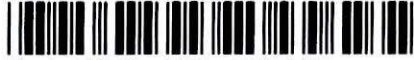
Specifications could not be found.

Plex 3/6/18 12:24 PM Dart.Gagnon.Michelle



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Container No: S081380



Part: D350-748-143TRN

Job No: 173668

Serial No/Batch: S081380

Revision:

Inspector:

Exp Date:

Instructions:

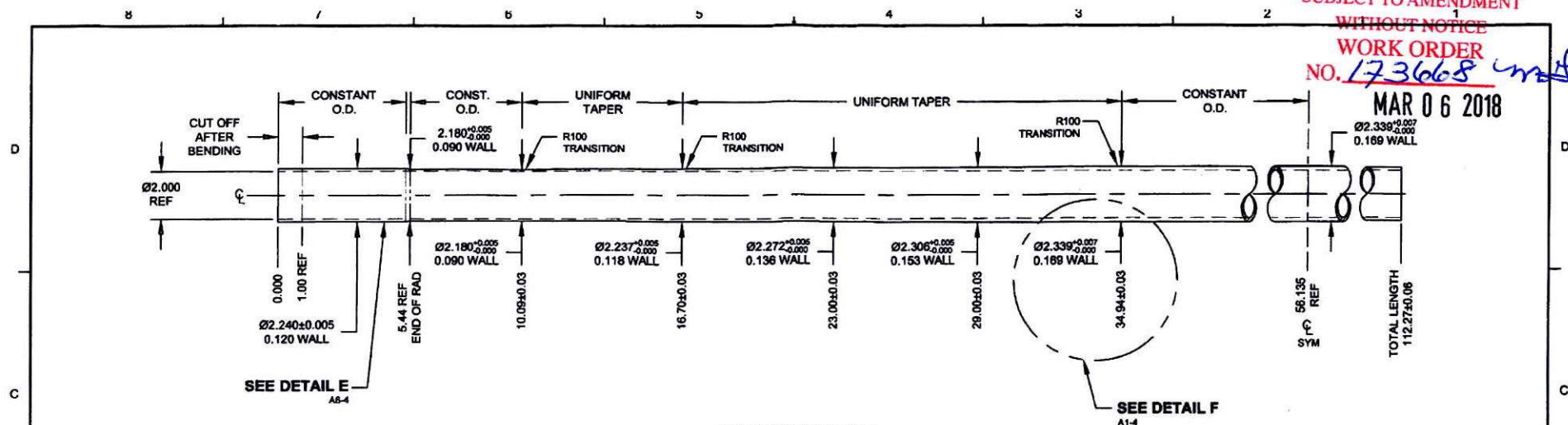
Date: 08/15/18

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SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 173668 *uncl*

MAR 06 2018

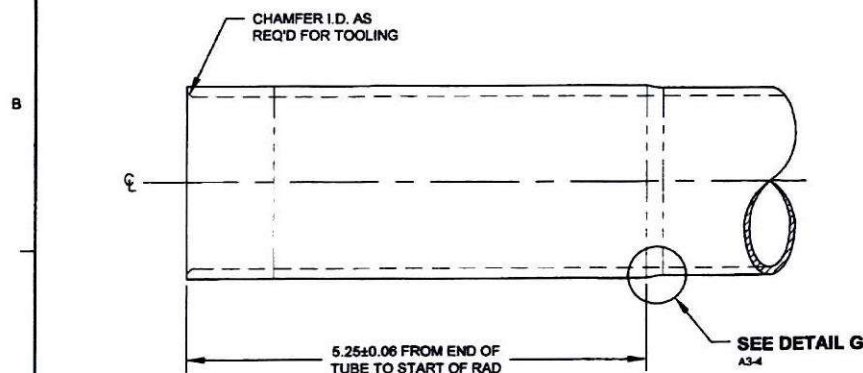


**D350-748-143TRN
TURNING DETAIL**

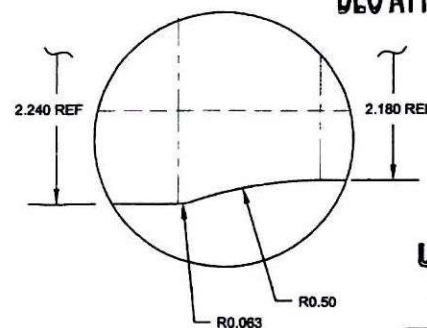
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2015 MAR 18 *ap*

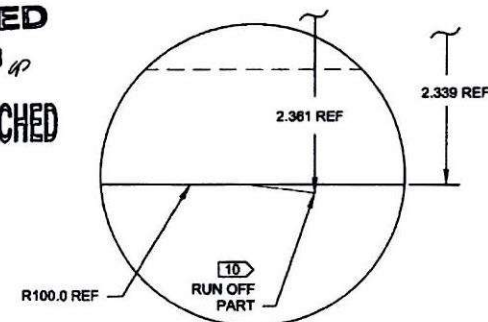
DEO ATTACHED



**DETAIL E:
CROSSTUBE CUFF** C7-4
SCALE 3X



**DETAIL G:
CUFF TRANSITION** A5-4
NOT TO SCALE



UNDER REVIEW
15/1/26

**DETAIL F:
TOOL RUN-OFF** C3-4
NOT TO SCALE

DESIGN	<i>ap</i>	DART AEROSPACE LTD	
DRAWN	<i>ap</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ap</i>	DRAWING NO. D350-748-143	REV. A
MFG. APPR.	<i>ap</i>	TITLE	SHEET 4 OF 4
APPROVED	<i>ap</i>	CROSSTUBE (AS 350/355 HI FWD)	SCALE
DE APPR.	<i>ap</i>		NTS
DATE	15.01.21	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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DART AEROSPACE LTD	Work Order: 173668
Description: Crosstube Assembly (AS350/355 High Fwd SS)	Part Number: D350-748-143
Inspection Dwg: D350-748-143 Rev: A	Page 1 of 2

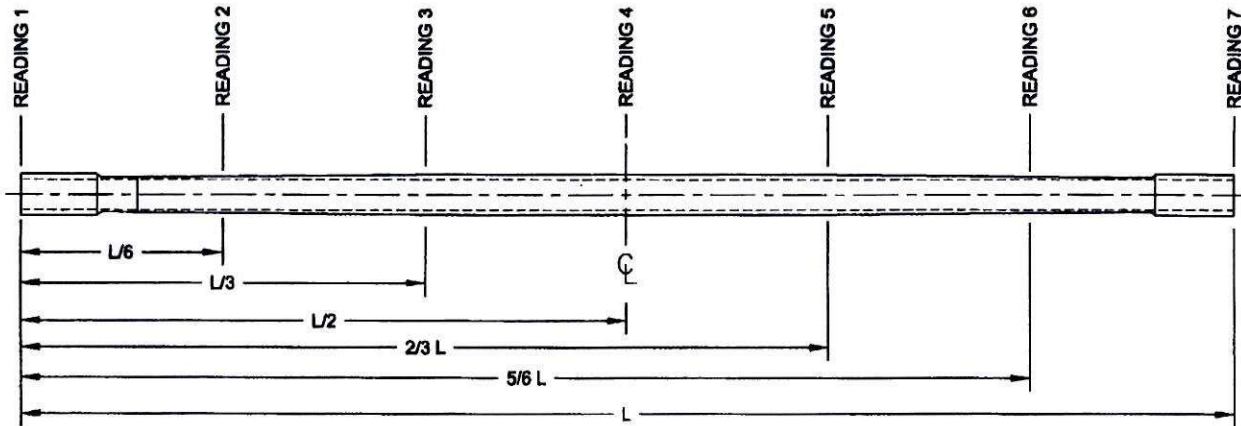
FIRST ARTICLE INSPECTION CHECKLIST

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+/-0.005	2.245	✓		BLM 3" 04	
	2.180	+0.005/-0.000	2.185	✓			
	2.180	+0.005/-0.000	2.185	✓			
	2.237	+0.005/-0.000	2.242	✓			
	2.272	+0.005/-0.000	2.276	✓			
	2.306	+0.005/-0.000	2.3105	✓			
	2.339	+0.007/-0.000	2.3455	✓		Vern 08	
	2.339	+0.007/-0.000	2.346	✓		Vern 08	
	0.062	+/-0.010	.062	✓		RG	
	5.25	+/-0.060	5.249	✓		Vern 08	
	R0.063	+/-0.010	.063	✓		RG	
	R0.50	+/-0.030	.500	✓		RG	
SIDE B	2.240	+/-0.005	2.245	✓		BLM 3" 04	
	2.180	+0.005/-0.000	2.185	✓			
	2.180	+0.005/-0.000	2.185	✓			
	2.237	+0.005/-0.000	2.242	✓			
	2.272	+0.005/-0.000	2.277	✓			
	2.306	+0.005/-0.000	2.311	✓			
	2.339	+0.007/-0.000	2.3455	✓		Vern 08	
	2.339	+0.007/-0.000	2.346	✓		Vern 08	
	0.062	+/-0.010	.062	✓		RG	
	5.25	+/-0.060	5.249	✓		Vern 08	
	R0.063	+/-0.010	.063	✓		RG	
	R0.50	+/-0.030	.500	✓		RG	
	112.27	+/-0.060	112.27	✓		Tape	

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WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L = 0"	.137	.143	.139	.131	.012	0.030"
READING 2 L = 18.71	.147	.143	.145	.141	.006	
READING 3 L = 37.42	.191	.195	.195	.191	.004	
READING 4 L = 56.14	.192	.191	.192	.193	.002	
READING 5 L = 74.85	.193	.199	.195	.188	.011	
READING 6 L = 93.56	.147	.140	.144	.144	.007	
READING 7 L = 112.27	.143	.137	.140	.139	.006	

Calibration Result

Actual Block Thickness: 100 - 200

Sitescan 250 Measured Thickness: 100 - 200

Measured by: M. [Signature]
Date: 2018-06-13

Audited by: [Signature] 18-06-20
Date:

Preliminary Approval:
Date:

Rev	Date	Change	Revised by	Approved
A	15.09.09	New Issue (P/O D350-748-103)	KJ [Signature]	[Signature]